

Date: Thursday, 1/17/2008 3:31:54 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER DECKPLATE 350
Job Number : 36850	
Estimate Number : 10357	
P.O. Number :	Part Number : D2344
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D2344 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : F
Previous Run : 33262	Material :
Written By :	Due Date : 2/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>808 01 18</u>	
Comment : Est Rev:D 00.06.26 Removed P/O for powder coat EC Est Rev:E 07-07-04 Asper Rev F JLM*	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.7823 sf(s)/Unit Total : 7.8225 sf(s)

Material: 2024-T3 QQ-A-250/5) .063

Batch 106223

IB 8-1-21

2.0	WATER JET	REV <u>E</u>	FLOW WATER JET
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REV E

IB 8-1-21



Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-1-21



10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/01/02 10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL/MED FAB

1-Deburr sharp edges

IB 8-1-21

2-Countersink holes per Dwg D2344

MF 08-01-25 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 28/02/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/17/2008 3:31:54 PM
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Process Sheet

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Drawing Name: LITTER DECKPLATE 350

Job Number: 36850

Part Number: D2344

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/08 (10)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-00-28 (X10)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

08-01-31 (X10)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-01-31 (10)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Identify and Stock

Location: 57185

AS 08/02/01 (X10)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/02/04

Job Completion



2008/2/04 (10)

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	36850
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

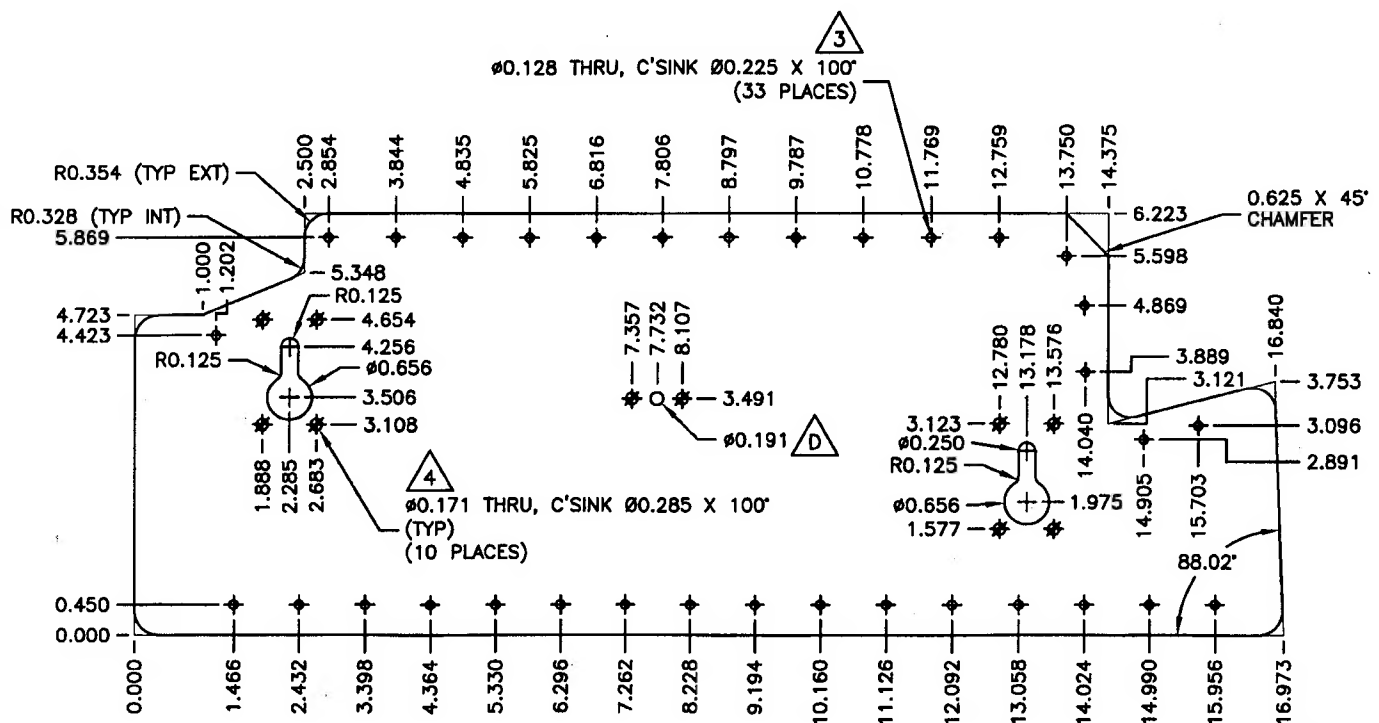
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.225	X			
5.598	+/-0.010	5.598	X			
4.869	+/-0.010	4.869	X			
3.889	+/-0.010	3.889	X			
3.096	+/-0.010	3.096	X			
2.891	+/-0.010	2.891	X			
16.973	+/-0.010	16.973	X			
0.450	+/-0.010	0.450	X			
4.423	+/-0.010	4.423	X			
4.723	+/-0.010	4.723	X			
1.202	+/-0.010	1.202	X			
5.869	+/-0.010	5.871	X			
4.654	+/-0.010	4.654	X			
Ø0.656	+0.005/-0.000	0.657	X			
1.888	+/-0.010	1.888	X			
2.285	+/-0.010	2.285	X			
2.683	+/-0.010	2.683	X			
Ø0.171	+0.005/-0.000	0.176	X			
3.491	+/-0.010	3.493	X			
Ø0.191	+0.005/-0.000	0.196	X			
3.123	+/-0.010	3.124	X			
1.975	+/-0.010	1.975	X			
Ø0.128	+0.005/-0.001	0.133	X			

Measured by:	LB	Audited by:	2	Prototype Approval:	N/A
Date:	8-1-21	Date:	08/06/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	BE

DESIGN KE		DRAWN BY JC		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B		APPROVED H		DRAWING NO. REV. F D2344 SHEET 1 OF 1	
DATE 07.06.07			TITLE SCALE LITTER DECK PLATE, 350 1:3		
A	95.01.14		NEW ISSUE		
B	95.02.09		MOVED KEY HOLES		
D	95.03.06		0.191 WAS 0.197		
E	98.06.19		0.063-0.071 THICK WAS 0.071 (TSR A371)		
F	07.06.07		C'SINK Ø0.285 WAS Ø0.308		



D2344 LITTER DECK PLATE. 350

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4**
(REF. DART SPEC. M2024T3S)
- 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3**
- 3) COUNTERSINK HOLES MARKED ∇ TO $\varnothing 0.225 \times 100^\circ$**
- 4) COUNTERSINK HOLES MARKED ∇ TO $\varnothing 0.285 \times 100^\circ$**
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010**
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED**
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED**
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36850

RELEASED

07.06.22

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